

Friday, 5/25/2007 8:19:07 AM  
Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 FLOAT SKIDTUBE
Job Number	: 32594	Part Number	: D3391015
Estimate Number	: 11437	Drawing Number	: D3391 REV.F
P.O. Number	: <u>NIA</u>	Project Number	: N/A
This Issue	: 5/25/2007 S.O. No. <u>NIA</u>	Drawing Revision	: F
First Rev.	: NC	Material	: <u>NIA</u>
First Issue	: <u>NIA</u> Type : LANDING GEAR	Due Date	: 6/20/2007
Previous Run	: 32593	Qty:	3 Um: Each
Written By	:		
Checked & Approved By	: <u>JA 07.05.28</u>		
Comment	: est rev A 05.12.13 New issue EC		
	: est rev B 06.02.09 Dwg @ revD EC		
	: est rev C 07.03.13 dwg @revF ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6014090	ALUMINUM EXTRUSION
-----	----------	--------------------



Comment: Qty: 1.0000 f(s)/Unit Total: 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty Part Number Description Batch

1 D6014-090 Extrusion 26540

Identify as D3391-3

MS 07/06/25

①

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: FA & Dwg D3391 Rev: FMS/ 07/06/25

①

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS/ 07/06/25

①

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS

1-Machine as per Folio FA 599 Rev: AA & Dwg D3391 Rev: F




2-Deburr

JL 07/07/09



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.11.02	8	$4.75 - 0.130 = 4.62$ <del>Weight of tube is 4.52</del> <del>normal</del> $4.2 \pm 0.25 = 4.45$	 per 042 07.11.02	ACCEPTABLE DEVIATION	 per 042 07.11.02	 per 042 07.11.02		

NOTE: Date & initial all entries



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Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 32594

Part Number: D3391015

Job Number:



Seq. #

Machine Or Operation:

Description:

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL 07/07/09

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SL 07/07/09 (1)

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

DP 7-11-2

8.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391

DP 7-11-5

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 7/11/05

PPD

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8808 (ALL HOLES)

3-Drill and c' sink wearshoe holes as per Dwg D3391

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391  
Debur

5- Transfer holes from D3391-013 for electric step in tube

DP 7-11-5 (2)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SL 7/11/05 (2)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 07/11/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.11.02	9	$4.83 - 0.13 = 4.62$ <del>It</del> HEIGHT OF EXTENSION IS 4.62" Nominal $4.25 \pm 0.25 = 4.45$	PH 07.11.02 per USS 042	ACCEPTABLE DEVIATION	PH 07.11.02 per USS 042	 7/11/05	PH 07.11.02 per USS 042	 7/11/05

NOTE: Date & initial all entries



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Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 32594

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

H 7-11-6

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/11/06

(2X)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/11/06 (2)

15.0

AESS10KB366

INSERT



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

18 AESS10KB366 Insert

M104818

FL

16.0

NAS1330C3KB316

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 NAS1330C3KB316 Insert

M104818

FL

17.0

NAS1330C3KB266

INSERT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 NAS1330C3KB266 Insert

M104651

FL

18.0

NAS1330C3KB216

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 NAS1330C3KB216 Insert

M104611

FL 07/11/06 (2)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:19:07 AM  
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## Process Sheet

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Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 32594

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

NAS1330C3KB166

INSERT



NAS1330S3KB166



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch  
12 NAS1330C3KB166 Insert

m104819

FL

20.0

NAS1330C4KB151

INSERT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
4 NAS1330C4KB151 Insert

m104652

FL

21.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty Part Number Description Batch  
1 D2646 Aft Cap

B31335

FL

22.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

B34943

FL

23.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

B33869

FL

24.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B33868

FL

25.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B33870

FL 07/11/07 (2)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 32594

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

2

AN3C4A

Bolt

m105559

~~m105559~~

m105143

FL

27.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

m106112

FL

28.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty

Part Number

Description

Batch

2

AN960C10L

Washer

m105143

FL

29.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty

Part Number

Description

Batch

2

NAS1515H3L

Washer

m105116

FL

30.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts per "insert installation detail" of dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date:

m105585  
08-07

FL 07/11/07 (2)

31.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL 07/11/07 (2)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 21/10/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Friday, 5/25/2007 8:19:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 FLOAT SKIDTUBE

Job Number: 32594

Part Number: D3391015

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*w/032523A*

33.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Don't lot*

Job Completion



*U 07.11.07*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order:	32594
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: F	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.501	✓			
88.93	+/-0.030	88.93	✓			
<del>44.995</del>	+/-0.030					
3.200	+/-0.010	3.203	✓			
1.526	+0.000/-0.030	1.520	✓			
0.200	+/-0.010	0.200	✓			
7.500	+/-0.010	7.499	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
<del>0.400</del>	+/-0.010					
3.300	+/-0.010	3.290	✓			
0.200	+/-0.010	.206	✓			
3.520	+/-0.010	3.522	✓			
0.687	+0.010/-0.000	.690	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.489	✓			

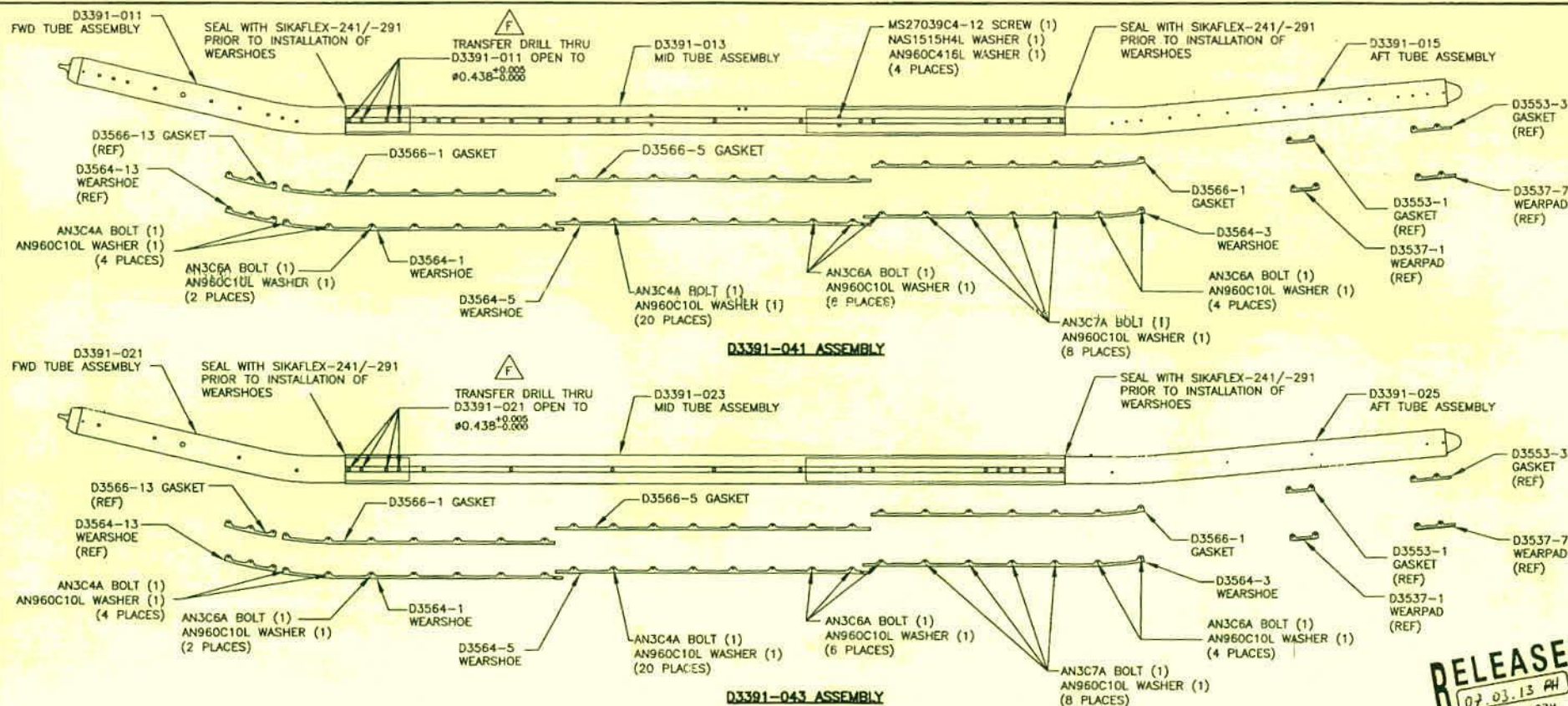
Measured by:	MS/JL	Audited by:	gmk	Prototype Approval:	N/A
Date:	07/04/25	Date:	07/07/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	









# D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER

## GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C'SINK #0.391/#0.425 x 100' AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		412 FLOAT SKIDTUBE

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

DRAWING NO.  
D3391

REV. F  
SHEET 1 OF 5

SCALE  
NTS

RELEASED  
07.03.13 AH  
per E-N #934

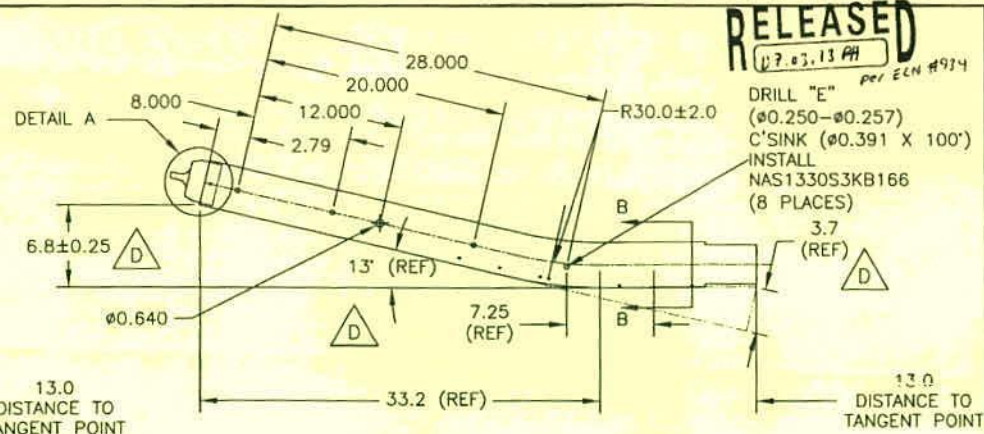
NO. 32594  
WORK ORDER  
SUBJECT TO APPROVEMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY



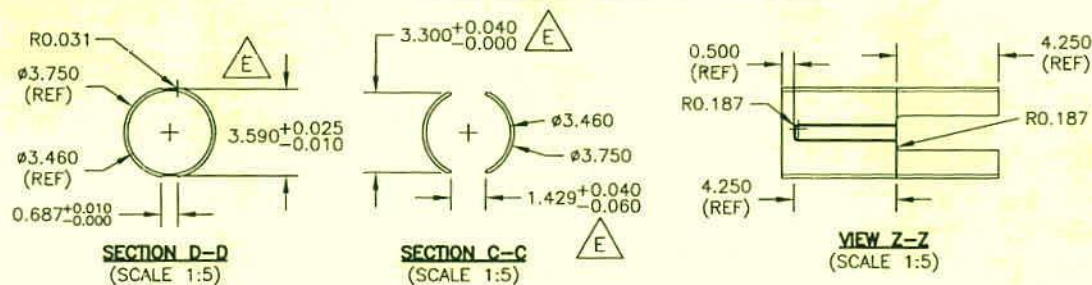




DRILL "E"  
(Ø0.250-Ø0.257)  
C'SINK (Ø0.391 X 100°  
INSTALL  
NAS1330S3KB166  
(8 PLACES)




D3391-021 ASSEMBLY AND BENDING DETAIL



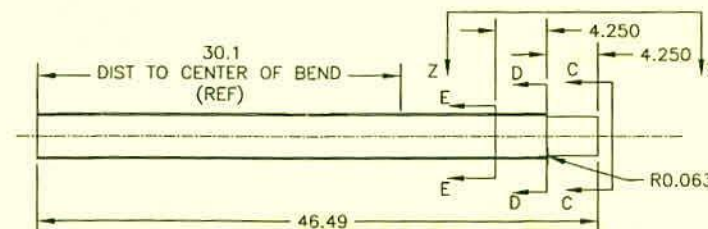
**VIEW Z-Z**  
(SCALE 1:5)

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)


 DRILL "E"  
 (ø0.250-ø0.257)  
 C'SINK (ø0.391 X 100")  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

**SECTION B-B**  
(SCALE 1:5)



**D3391-1 DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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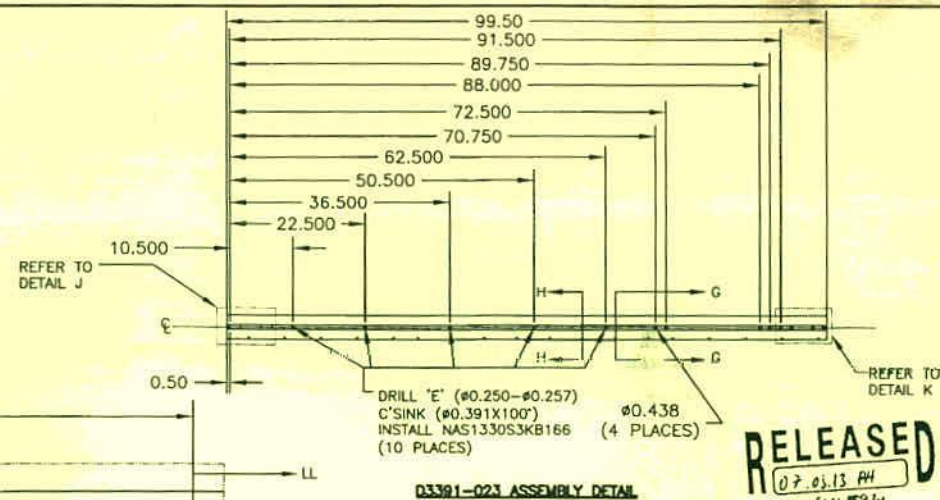
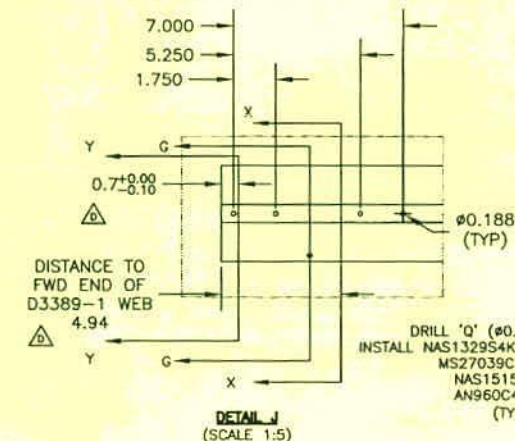
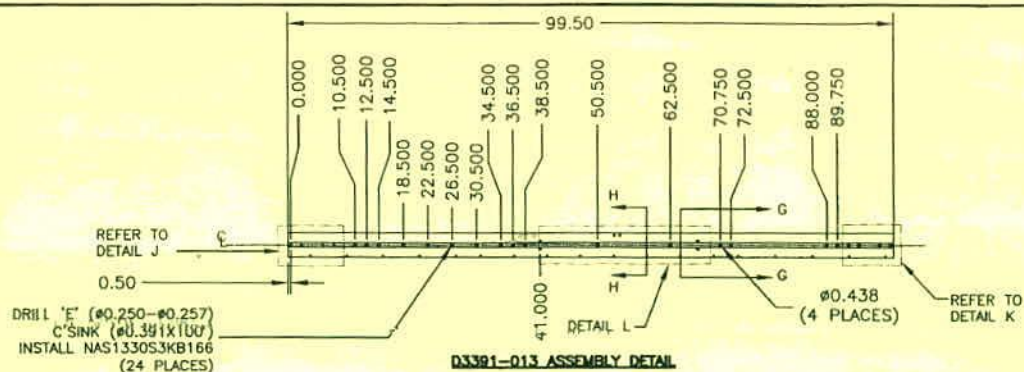
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3391	REV. F SHEET 2 OF 5
DATE 07.01.18		TITLE 412 FLOAT SKIDTUBE SCALE: 1:10	

SHOP COPY  
ENGINEERING  
RETURN TO  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32594



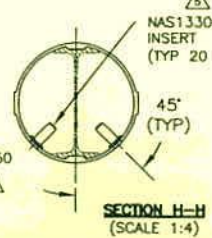
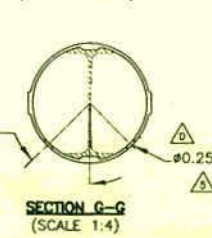
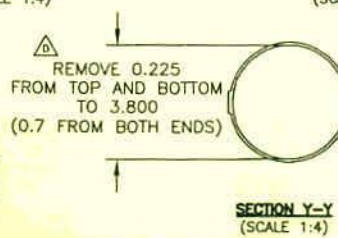
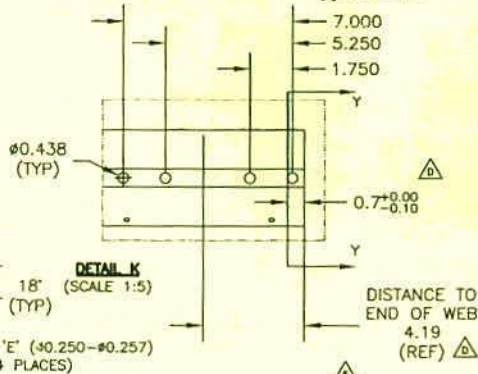
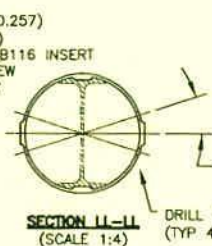
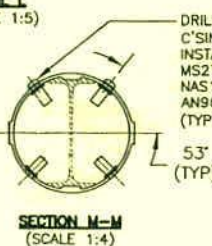
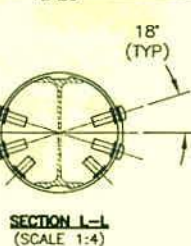
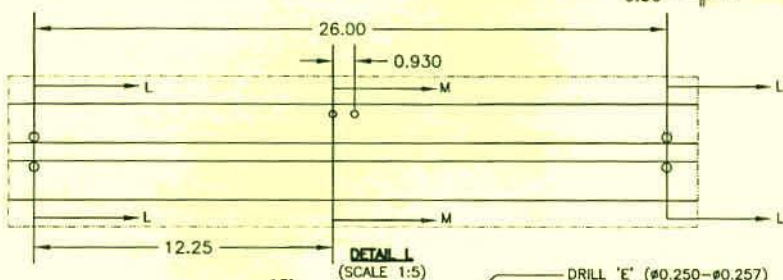






D3391-023 ASSEMBLY DETAIL

RELEASED  
07.03.13 RH  
Doc # 14 #934



REMOVE 0.225 FROM TOP AND BOTTOM TO 3.800 (0.7 FROM BOTH ENDS)

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DESIGN RH	DRAWN BY RH	DART AEROSPACE USA, INC. PORT HOLE, WA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 3 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:20	

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

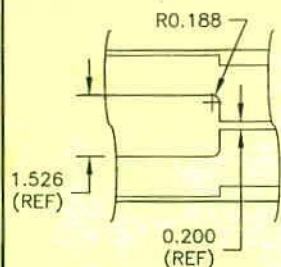
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER OSI 015

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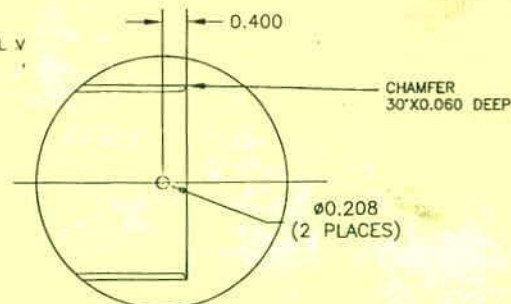
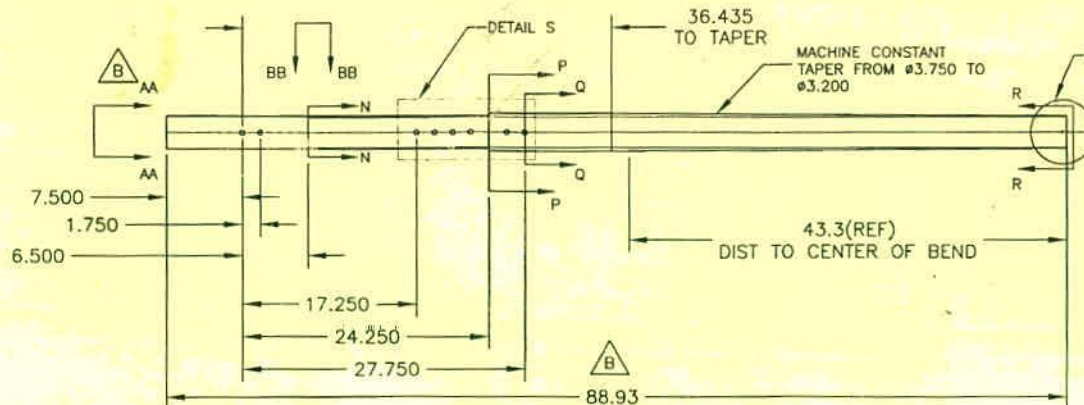






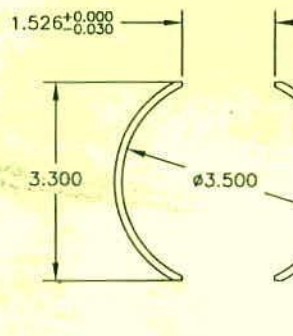


VIEW BB-BB  
(SCALE 1:3)

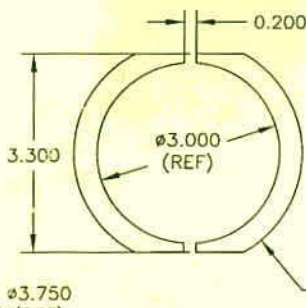


DETAIL V  
(SCALE 1:2)

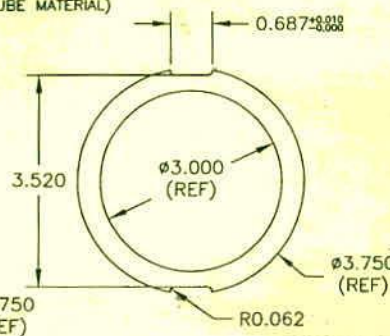
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



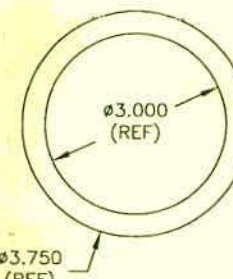
SECTION AA-AA  
(SCALE 1:2)



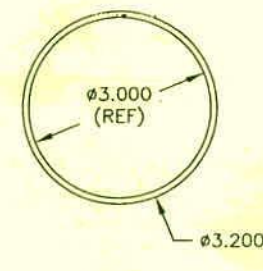
SECTION N-N  
(SCALE 1:2)



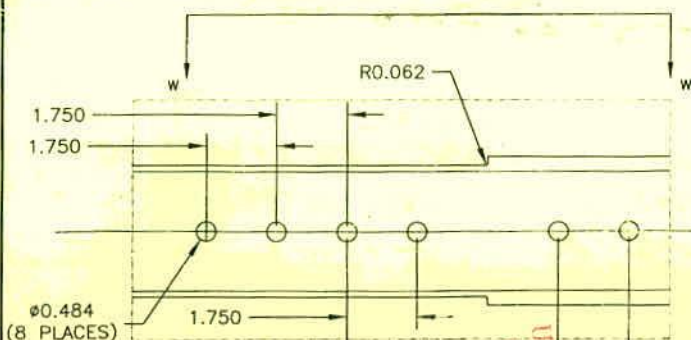
SECTION P-P  
(SCALE 1:2)



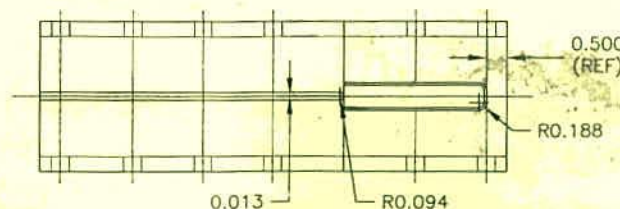
SECTION Q-Q  
(SCALE 1:2)



SECTION R-R  
(SCALE 1:2)



DETAIL S  
(SCALE 1:3)



VIEW W-W  
(SCALE 1:3)

RELEASED  
07 05.13 PM  
P-12 ECU #934

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DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, MA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	

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